

Date: Tuesday, 19/08/2008 4:04:11 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT CAP		
Job Number	: 41435			Part Number	: D2646		
Estimate Number	: 10312			Drawing Number	: D2646 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/08/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 20/09/2008 Qty: 50 Um: Each		
Previous Run	: 37755						
Written By	:						
Checked & Approved By	: NO 08.8.19						
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>7000</u> <u>C20808121</u> (50) 1-Spin as per Dwg D2646 2-Material release note required		
2.0	D2646P	Aft Cap
Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) AFT CAP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646 <u>08/08/28</u> (50) (counter)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646.		

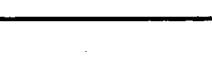
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT CAP
Job Number: 41435		Part Number: D2646
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
2-Open holes to .297 as per Dwg D2646.		
3-Deburr 		
6.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP 		
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 		
8.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 		
START TIME: 1:45 		
OVEN TEMPERATURE: 320°F 		
FINISH TIME: 2:15 		
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 		
10.0	ALS71032130 	Insert 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s) 		
INSERT 		
Batch: M108523 		
11.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 		
Install inserts as per Dwg D2646 		
12.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:12 PM
User: Julie Lecocq

Process Sheet

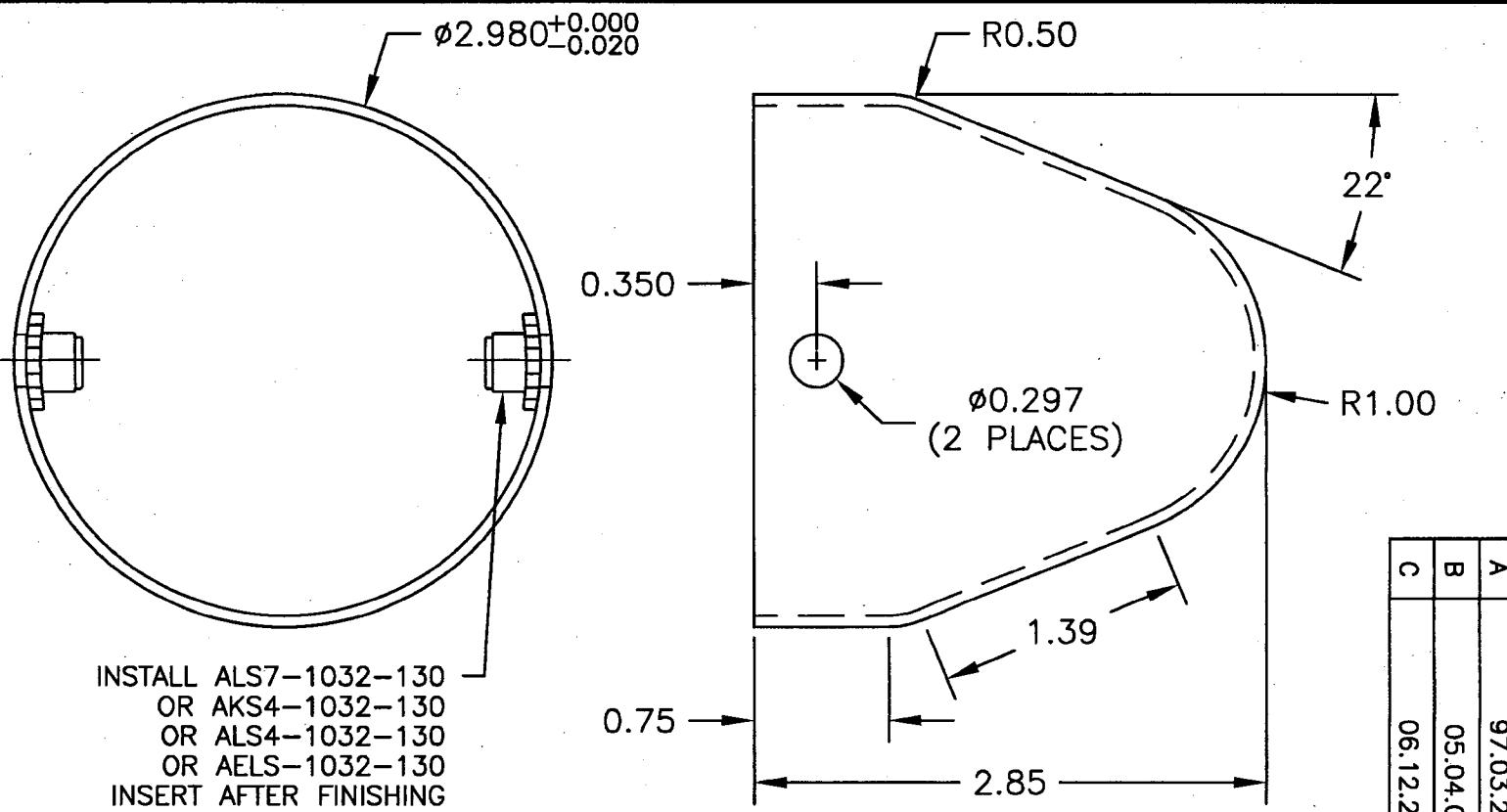
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT CAP
Job Number: 41435		Part Number: D2646
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	PACKAGING 1 	PACKAGING RESOURCE #1  50x
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		FP - 7 MF 08/09/15
14.0	QC21 	FINAL INSPECTION/W/O RELEASE  08/09/15 JJ
Comment: FINAL INSPECTION/W/O RELEASE		MF 08-09-15
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

DESIGN DS	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC.
CHECKED <i>MM</i>	APPROVED <i>MM</i>	PORT HADLOCK, WA
DATE 06.12.20	DRAWING NO. D2646	REV. C
A 97.03.25	NEW ISSUE	SHEET 1 OF 1
B 05.04.01	CHANGE TO CLOSED INSERTS	SCALE 1:1
C 06.12.20	CHANGE TO OPEN ENDED INSERTS	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4633*



Sieg's ~~Metall~~ ~~Engineering~~ Ltd.

~~Metall~~ ~~Engineering~~

Packing Slip

Packing Slip No.:

35672

Date:

08/27/2008

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 7000	Sold By: KAULBARS, KALE
Shipped By: fedex	Ship Date: 08/27/2008
Tracking No.:	

Item No.	Unit	Description	Quantity
B2646P	EACH	AFT GUN POD V.C	50
<i>08/27/08</i>			
Comment:			



Steel Manufacturing Ltd.

Welding and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Aug. 27/08

Customer: Dart Aerospace

Packing Slip: 35672

Part#:	Quality	Material	Check holes	Debur edges	Insp. By
B41435 rev.C	100	14G 1100	N/A	✓	JK

Notes:

Aug 27/08

Material Certification Attached: Yes



ALCOA Metal Products
1480 Manheim Pike
Lancaster Pa. 17601

Certification of Test Results

P/N 970200 PO 38C880

SOLD TO

SHIP TO

CERT NO 3900675996
DATE 4/23/2007
SKID NO 661033
SKID WGT 9,885
PAGE 1 OF 1

ORDER NO	LGS947	PO NO	43-62756		MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO			
ALLOY	1100	TEMPER	O	FORM	
GAUGE	.06300	WIDTH	48.5000	LENGTH	

LOT: 334171 COIL: B01 DROP: 07T0187

INGOT	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.31	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI

TAIL ULTIMATE STRENGTH 13.0 KSI

HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI

TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI

HEAD ELONGATION (G.L. = 2 IN) 32 %

TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 O,

ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 7L4-736-4840

* END OF CERTIFICATION *

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and test samples representative of the material and its composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our products. Certification and test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to COPPER & BRASS SALES PO: 38C880 Part Order No. 376276

TR direct signature
0001/001

